

Date: Thursday, 02/04/2009 2:25:43 PM
User: Julie Dawson

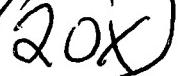
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: ARM		
Job Number	: 46845						
Estimate Number	: 11048						
P.O. Number	:			Part Number	: D28443		
This Issue	: 02/04/2009	S.O. No.	:	Drawing Number	: D2844 REV A		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / /	Type	: MACHINED PARTS	Drawing Revision	: A		
Previous Run	: 39543			Material	:		
Written By	:			Due Date	: 10/04/2009		
Checked & Approved By	: <u>JWD 09.04.09</u>			Qty:	/10 Um: Each		
Comment	: Est: B 00.11.01 Removed P/O for Powder Coat - in house processEC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W035	304 RD Tube .500 x .035W 
	Comment: Qty.: 1.8533 f(s)/Unit Total : 18.5325 f(s) 304 RD Tube .500 x .035W M304TR0500W035 Punch 304/316 Seamless tubing with 2B finish, 1/2" OD x .035 Wall 19.82" long (Hole ctr. to hole ctr.) using Jig DT 8012 Batch <u>M111704</u>	 <u>M-1 09/05/21</u>
2.0	BRAKE NC	NC BRAKE 
	Comment: BAND SAW Form per Dwg D2844 using brake and bending Jig DT 8238-B Deburr	 <u>M-1 09/05/21</u> 
3.0	QC5	INSPECT WORK TO CURRENT STEP 
	Comment: INSPECT WORK TO CURRENT STEP	 <u>S 09/05/21</u> <i>counts</i> 
4.0	POWDER COATING	POWDER COATING 
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3 START TIME: <u>7:30 AM</u> OVEN TEMPERATURE: <u>400°F</u> FINISH TIME: <u>8:00AM</u>	 <u>M111472</u> <u>41 09-05-26</u> 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:25:43 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 46845

Part Number: D28443

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(20)

Fx 09/05/26

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0 QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure parts are still as per dwg D2844

7.0 PACKAGING 1

PACKAGING RESOURCE #1



(20)

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 265

9/5/27

50

8.0 QC21

FINAL INSPECTION/W/O RELEASE



09/05/27

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

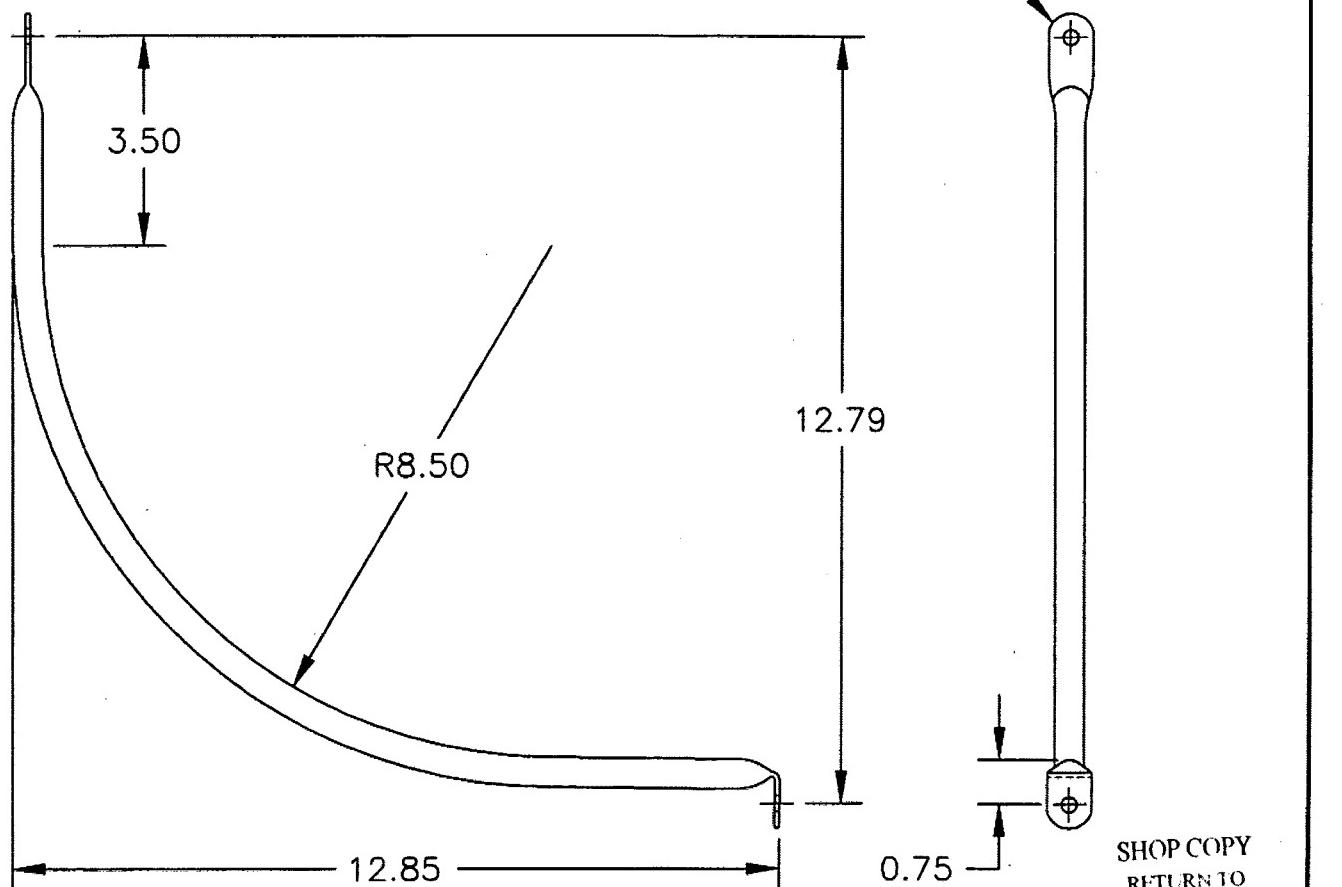
NOTE: Date & initial all entries

DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>PAH</i>	APPROVED <i>S</i>	DRAWING NO. D2844
DATE 98.10.14		REV. A SHEET 1 OF 2
	TITLE ARM	SCALE 1:3
A	98.10.14	NEW ISSUE

RELEASED
98.10.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 10845

MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

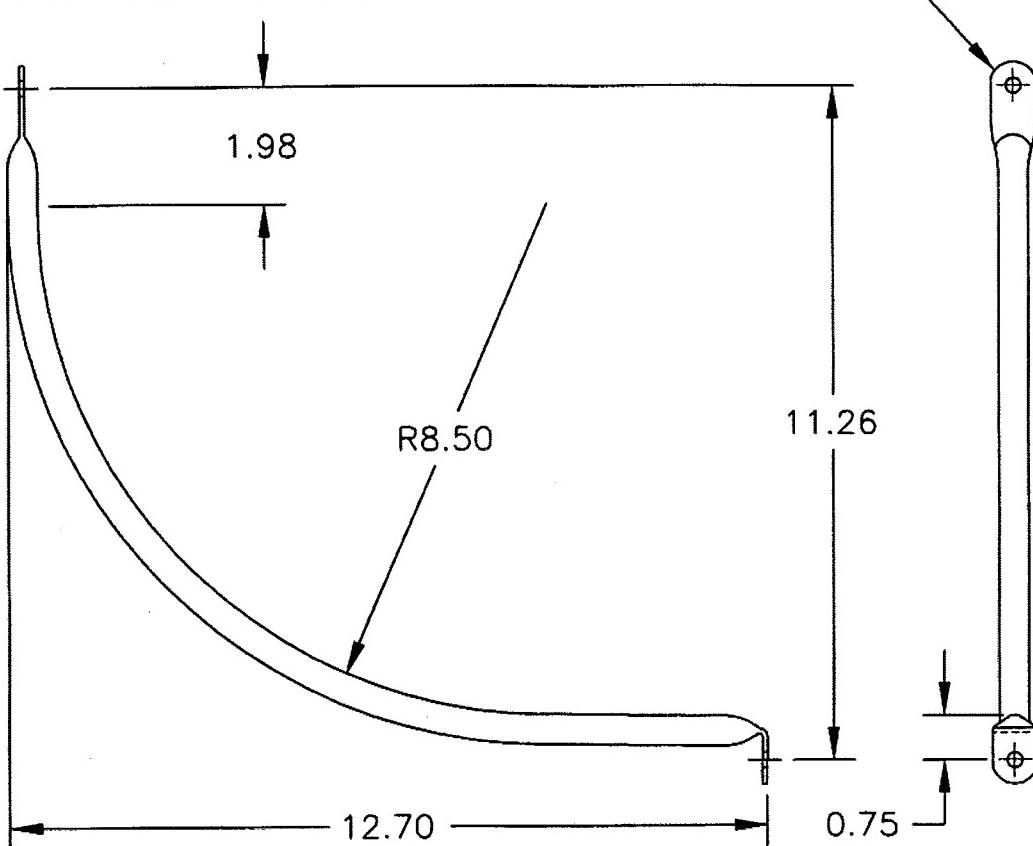
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DAA</i>	APPROVED <i>S</i>	DRAWING NO. D2844	REV. A SHEET 2 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3

RELEASED
18.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY
SUBJECT TO CHANGE WITHOUT NOTICE

NO. 46845

MATERIAL: AISI 304/316 SS TUBE, Ø0.50 x 0.035 WALL
ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3